

Date: Monday, 1/8/2007 10:53:18 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 30158D					
Estimate Number	: 10296					
P.O. Number	: N/A			Part Number	: D32203	
This Issue	: 1/8/2007 S.O. No. : N/A			Drawing Number	: D3220 REV A1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A1	
Previous Run	: 29382D			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 1/30/2007	
Checked & Approved By	: <i>[Signature]</i> 07.01.08			Qty:	12 Um: Each	
Comment	: Est Rev: A New Issue 05-11-06 JLM Est: B 06.11.15 waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M2024T3S050	2024-T3 .050 sheet		
		Comment: Qty.: 0.6233 sf(s)/Unit Total : 7.4794 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3220-3 Batch: <i>M103210</i>		
2.0	WATER JET	FLOW WATER JET		 <i>Dwg A1 Prg A1</i>
		Comment: FLOW WATER JET	SAD	07/01/20 <i>(12)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		 <i>SAD 07/01/20 (12)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD	07/01/20 <i>(12)</i>
4.0	QC8	SECOND CHECK		 <i>07/01/20 (12)</i>
		Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		 <i>07/01/20 (12)</i>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>SS/YL</i>	<i>07/01/20 (12)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:53:18 AM
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Drawing Name: DOUBLER

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Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>Po 7/01/23 (12)</i>
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>Po 7/01/23 (12)</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>Po 07/01/23 (12)</i>
		<i>do 07/01/23</i>

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30158D
Description: Doubler	Part Number:	D3220-3
Inspection Dwg: D3220 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

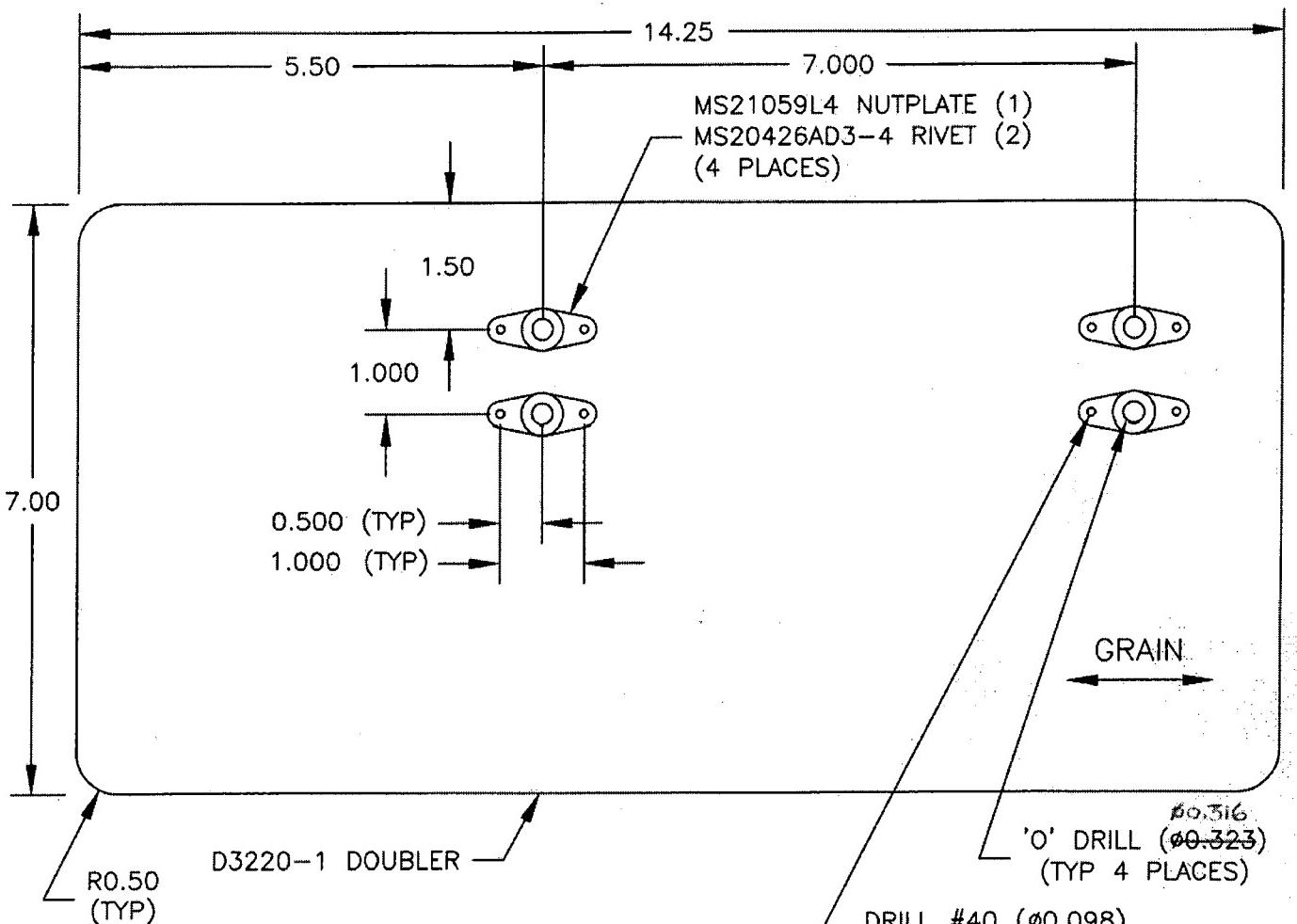
X First Article Prototype

Measured by:	SAD	Audited by:	MM	Prototype Approval:	N/A
Date:	07/01/20	Date:	07/01/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	P/O D412-698-013	KJ/RF  

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3220	SHEET 1 OF 2
DATE	TITLE		SCALE
03.10.16	DOUBLER		1:2
A	03.10.16	NEW ISSUE	
AI	CP/HF 03.11.13	CORRECTED Dim	

RELEASED
03.11.14**D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

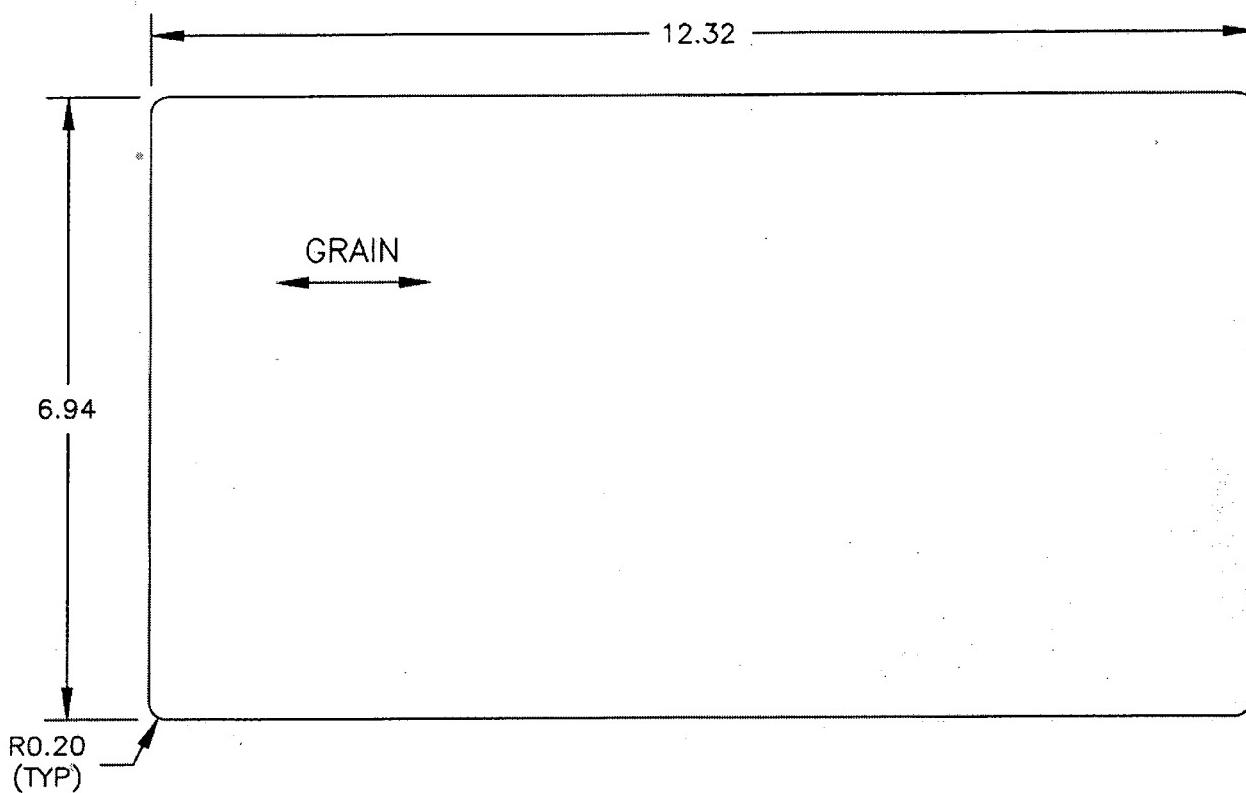
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3220	SHEET 2 OF 2
DATE	TITLE	DOUBLER	SCALE
03.10.16			1:2

RELEASED
03.11.14**D3220-3 DOUBLER**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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